

Work Order ID 51804

Page 1

Thursday, September 03, 2009 11:43:47 AM

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL ML

Date:

09-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

*S 9/10/08**HJ for BG 09/10/08***51804**

Work Order ID 51804

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Item ID: D350-636-012

Accept

Revision ID: F

Item Name: Skidtube RH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110



Skidtubes

Skidtubes

Skidtubes

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ Aluminum Rod ☐

10-Grind welds flush as per Dwg D2750

BE 02/09/14

AWM 9-9-15

BE 02/09/14

AWM 9-9-15

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Item ID: D350-636-012

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Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11- scribe batch #.

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

27 8 09/16

(4)

6

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

27 8 09/16

(4)

6

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

M 09 09 16 (17)

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Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

0.00 09-09-16 (1)

Work Order ID 51804

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Item ID: D350-636-012

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Setup Start



Revision ID: F

Item Name: Skidtube RH

Stop



Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes								
Skidtubes									
Skidtubes	Memo 1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750. 3-Open float holes to .500" (4 per Side) 4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5-Deburr and blow out all chips from inside of tube 6-Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>4112391</u> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> exp. date: <u>02/20/2010</u> 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M111999</u> 9-Grind welds flush as per Dwg D2750 10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750	0.00							

DP
9-9-28

DP 9-9-28

D 09.10.01

AWM 9-10-02

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Setup Start

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Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

2) S 09/10/06

(S)

/

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) S 09/10/06

(S)

/

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

2) M 09/10/07

(M)

/

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Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 112260</i> Memo START TIME: <i>11:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:30</i>	0.00 0.00	<i>bk 09-10-7</i>			<i>①</i>			
210  QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00	<i>HL 09/10/07</i>			<i>(X)</i>	<i>Ø</i>		
220  HandFinish Hand Finishing	HandFinishing Memo Install inserts as per dwg D2750	0.00 0.00	<i>HL 09/10/07</i>			<i>(X)</i>	<i>Ø</i>		

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Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



HandFinish

Hand Finishing

HandFinishing

Memo

0.00

⇒ 9/10/09

(X1)

✓

✓ 1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
X batch: N/A

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750
SIKA FLEX 241
✓ BATCH: M112391
EXP DATE: 10/20

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
✓ A/R 55-o-ring lube batch: M101223

5-Coat all exposed fasteners with "LPS Procyon"
batch: M104251

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ 8/26/09

(X1)

✓

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Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	Pick Kit	0.00							
Packaging 	Memo	0.00				9/10/08		QSP	
Packaging									
260 	QC4- 100% Inspect kits for completeness	0.00							
QC 	Memo	0.00				27802/10/08			
Quality Control									
270 	Packaging	0.00							
Packaging 	Memo	0.00							
Packaging	Package as per PPP D350-636-012								

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Item Name: Skidtube RH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13 HJ

09-10-8

Picklist Print

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17

Work Order ID: 51804

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	8,785.000	38.0000			

Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8785	
107441	16	
110768	8769	

AN3C5A

Purchased

No

230

Each

646.0000

34.0000

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	646	
111424	8	
111707	338	
112314	200	
112489	100	

AN3C6A

Purchased

No

230

Each

1,048.000

4.0000

BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1048	
110372	72	
111982	976	

X38 09/10/07

X34 09/10/07

X4 09/10/07

Picklist Print

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Work Order ID: 51804

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A		Purchased	No			230	Each	172.0000	4.0000			
												
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE	M 112720	x4 9/109/10/07
FG	2	
103964	2	
Main Warehouse		
ST	170	
110105	4	
110155	14	
110665	1	
110865	51	
111605	50	
111649	50	

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	167	
102180	1	
106896	1	
110105	65	
110847	100	

x1 9/109/10/07

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Page 3

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Work Order ID: 51804

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,450.000	38.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE	M 1126R	
FG	100	
103585	100	
Main Warehouse		
FP	-44	
112116	-44	
Main Warehouse		
ST	2394	
112116	2394	

X38 21 09/10/07

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

X1 21 09/10/07

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Work Order ID: 51804

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Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			

Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 272

34817 2

36230 8

37303 1

39587 2

40726 2

41114 2

42778 19

43754 2

44893 37

45556 69

46695 18

48278 110

D3488-042RevB

Manufactured No



Blade Fitting Assembly, RH



230 Each 9.0000 1.0000



X8 28 09/10/07

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 9

29043 1

44531 8

X1 24 09/10/07

Picklist Print

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-041RevC		Manufactured	No			230	Each	3.0000	8.0000			



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43816

B51584 9U

3

3

x8 9/10/10/07

D3492-043RevC Manufactured No



Plug Assembly

D3535-25RevB Manufactured No



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47523

B51642

11

11

x8 9/10/10/07

Picklist Print

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Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA		Manufactured	No			230	Each	21.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

45569

1

47011

2

47526

8

50266

10

x1 09/10/07

D3537-1RevC

Manufactured No



230

Each

46.0000

3.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

B51918

46

48288

3

50321

43

x3 09/10/07

Picklist Print

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA Washer		Manufactured	No			230	Each	105.0000	8.0000			

X?

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

B51908

X8

21 09/10/07

ST

105

38139

6

45353

16

47437

83

D3791-1RevA



Manufactured No

230

Each

18.0000

1.0000

Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

X1

21 09/10/07

Picklist Print

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Parent Item Name: Skidtube RH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA  Wearshoe		Manufactured	No			230	Each	18.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
40551	1	
47537	4	
50231	13	

X1 JH 09/10/07

D3793-3RevA

Manufactured No



Wearshoe

230	Each	22.0000	1.0000
-----	------	---------	--------



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
47720	11	
50216	11	

X1 JH 09/10/07

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Parent Item Name: Skidtube RH



Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-1RevA		Manufactured	No			230	Each	7.0000	1.0000			
												
Gasket												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

46530

47212

47721

B351668

7

1

2

4

V1 09/10/07

D3794-3RevA

Manufactured No

230

Each

27.0000

1.0000



Gasket

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

46531

47440

47722

50240

27

2

2

11

12

X1 09/10/07

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Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6 		Purchased	No			230	Each	1,132.000	4.0000			
NUT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1132	
110584	34	
111424	98	
112314	1000	

x4 24 09/10/07

MS21083C8



Purchased

No

230

Each

92.0000

1.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

x1 24 09/10/07

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Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-010  O-RING		Purchased	No			230	Each	345.0000	8.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	345	
110715	50	
110915	295	

D 2594-3/ B51613

X8 4P 09/10/07
X PTO ~~X 10/10/07~~ =>

NAS1611-013  O-RING		Purchased	No			230	Each	320.0000	8.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	320	
106513	11	
111424	109	
111758	200	

X8 208 09/10/07

W/O: 51804		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/07	N/A	Replace NAS 1611 - O10 "O" Ring FOR D2594-3/1350613	JE	09/10/07	28		S 09/10/06
09/10/07	N/A	D3536-25/1351663	JE	09/10/07	(X1)		S 09/10/06

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 03, 2009 11:43:54 AM

Work Order ID: 51804

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A  BOLT		Purchased	No			260	Each	112.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	112	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	4	
111605	50	
111684	50	

111684 50

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

111424 9/10/8 @ 54

Picklist Print

Page 13

Thursday, September 03, 2009 11:43:54 AM

Work Order ID: 51804

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2741RevC		Manufactured	No			260	Each	40.0000	1.0000			
												
Blade, 350 Skidtube												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	40	
20770	0	
45320	1	
47113	39	

47113 SD

D3493-1RevA

Manufactured No

260

Each

115.0000

2.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	115	
44902	15	
47710	100	

47710 SD

D3532-1RevA

Manufactured No

260

Each

43.0000

2.0000



Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	43	
38161	2	
44904	41	

44904 SD
9/10/08 @

Thursday, September 03, 2009 11:43:54 AM

Shop Packet Print

Page 13

Picklist Print

Thursday, September 03, 2009 11:43:54 AM

Work Order ID: 51804

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			260	Each	92.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

112243 SP

NAS1515H3L



WASHER

Purchased

No

260

Each

350.0000

4.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819	300	

x4 09/10/09

Picklist Print

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Thursday, September 03, 2009 11:43:54 AM

Work Order ID: 51804

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L  WASHER		Purchased	No			260	Each	129.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	129	
107581	34	
108964	1	
111650	94	

111650 scd

D2600-3-BENTRevD1  Extrusion Bent		Manufactured	No			110	Each	0.0000	1.0000			
D2744RevC  Cap		Manufactured	No			110	Each	50.0000	1.0000			

B 50675 BE 09/09/14

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	50	
44892	15	
47488	35	

1 BE 09/09/14

Picklist Print

Thursday, September 03, 2009 11:43:54 AM

Work Order ID: 51804

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			
												
350 I Beam												

B52305
D9-9-28

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	4	
50353	4	
Main Warehouse		
ST	2	
47124	1	
47681	1	

D2743RevB

Manufactured No

160

Each

294.0000

8.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	50	
50281	50	
Main Warehouse		
ST	244	
44891	2	
45555	177	
48275	65	

8 PD 09.10.09

Picklist Print

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Thursday, September 03, 2009 11:43:54 AM

Work Order ID: 51804



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA  Cross Bolt Spacer		Manufactured	No			160	Each	112.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	112
45560	22
47471	35
48276	55

BS1930 -> 4
PD 09.10.01

D3490-1RevA  Cross Bolt Spacer		Manufactured	No			160	Each	165.0000	4.0000			
--	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	165
45338	2
47118	4
47657	50
48277	109

PD 09.10.01

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

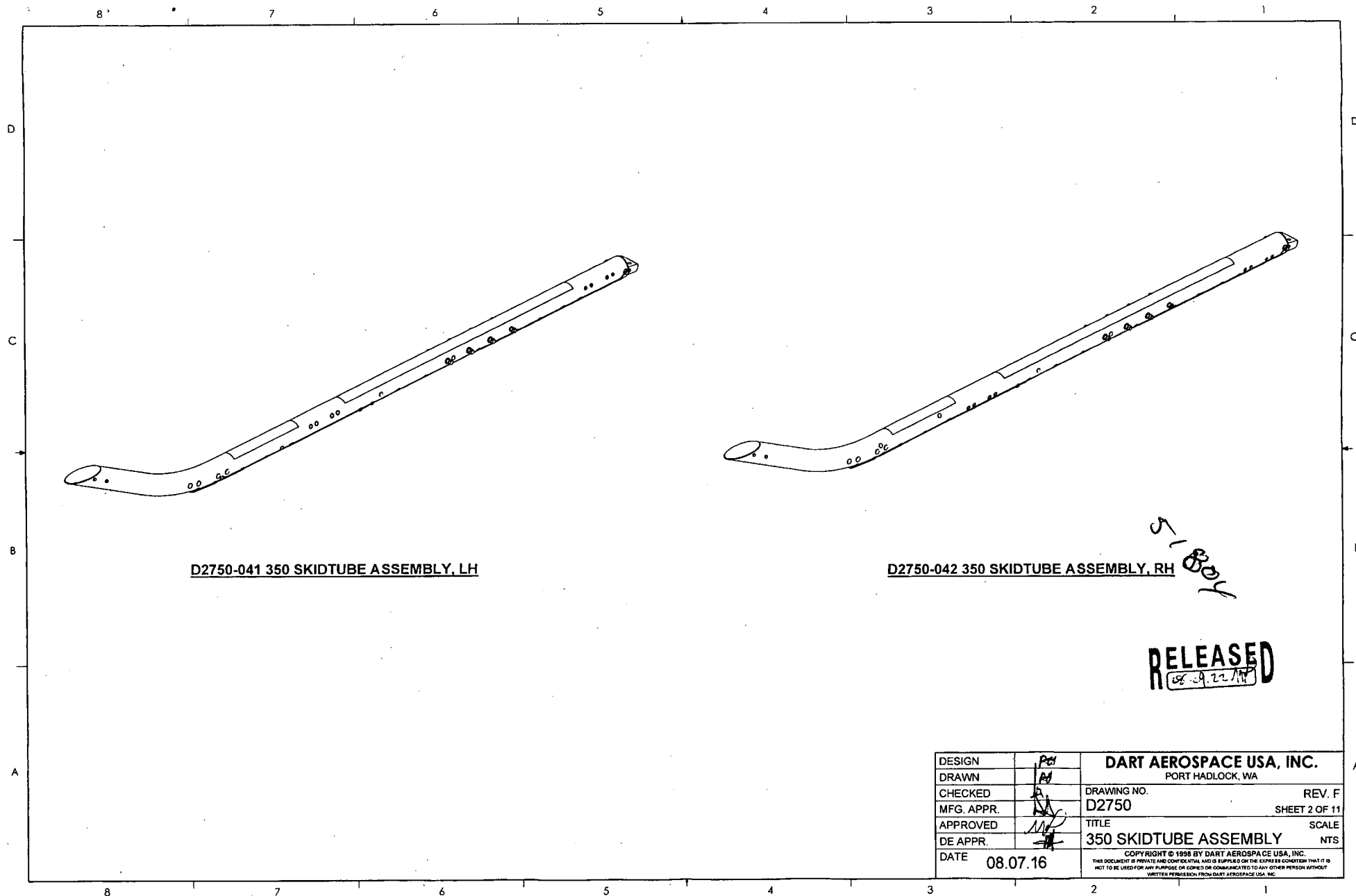
- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

8-800

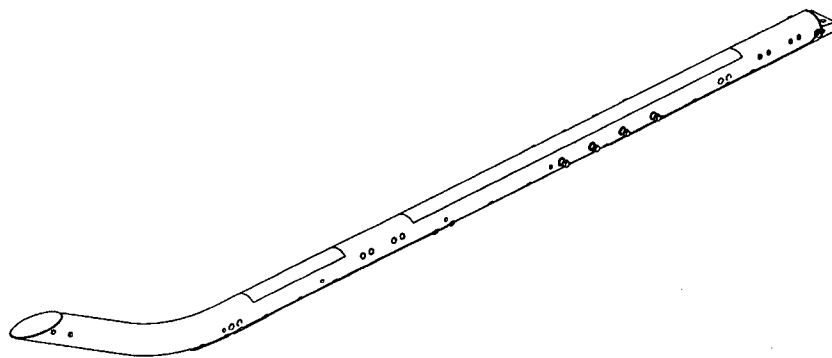
RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RA		
CHECKED	AS	DRAWING NO. D2750	REV. F
MFG. APPR.	AS		SHEET 1 OF 11
APPROVED	AS	TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	AS		
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

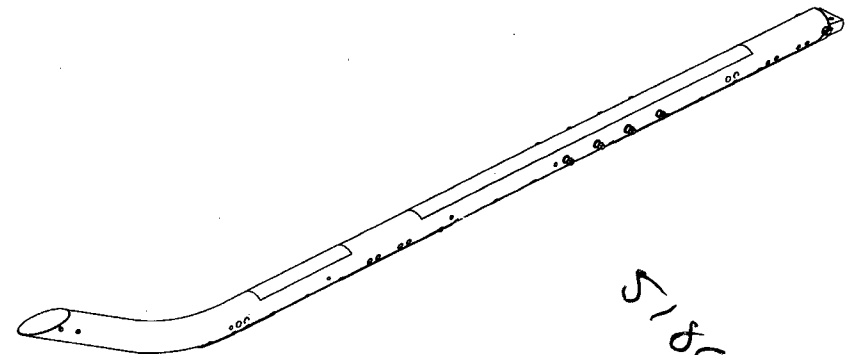
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DRAWN	AM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO. D2750	REV. F
MFG. APPR.	SA	SHEET 2 OF 11	
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR CONSUMED BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D2750-043 350 SKIDTUBE ASSEMBLY, LH

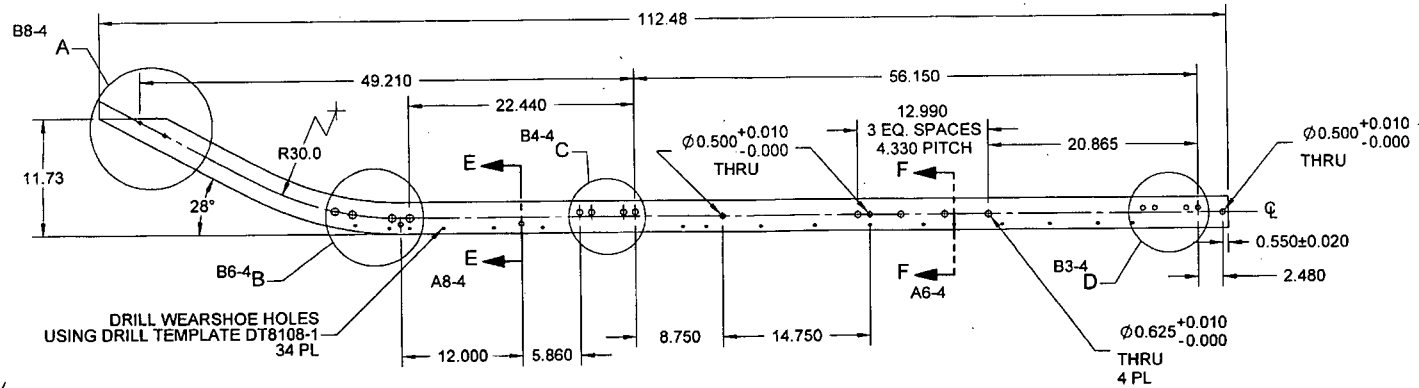


D2750-044 350 SKIDTUBE ASSEMBLY, RH

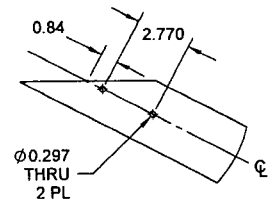
51808

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68-9-22/11

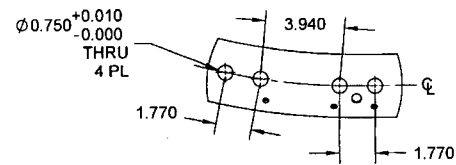
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MFG. APPR.	SA	SHEET 3 OF 11	
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	350 SKIDTUBE ASSEMBLY	NTS
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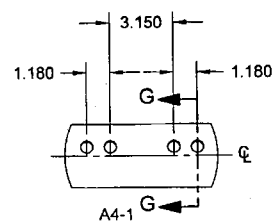
D2750-1 LH SKIDTUBE



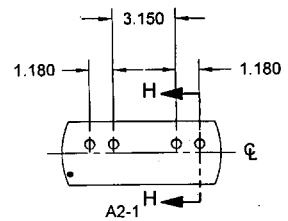
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DETAIL B
SCALE 2X



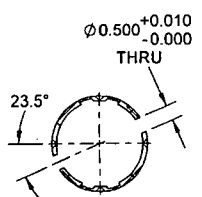
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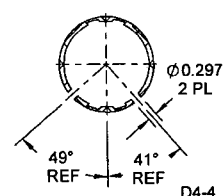
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51804

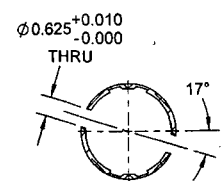
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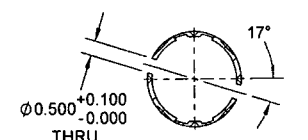
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL

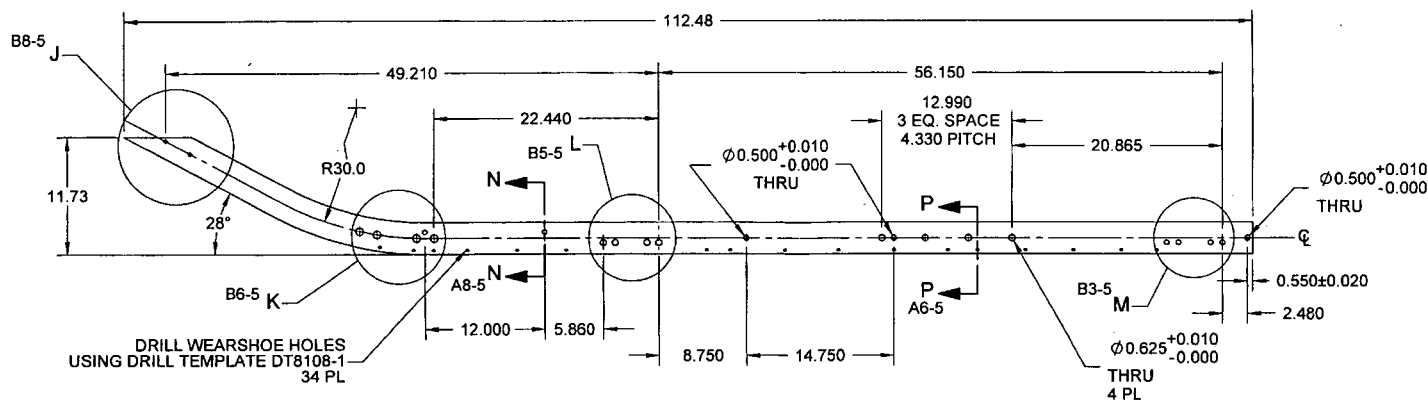


SECTION G-G
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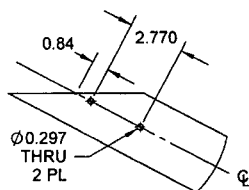


SECTION H-H
SCALE 3X, 4 PL

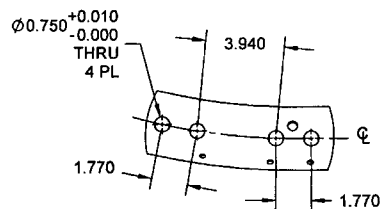
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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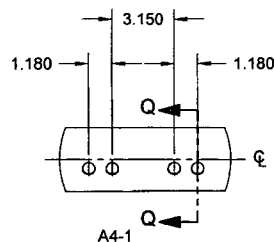
D2750-2 RH SKIDTUBE



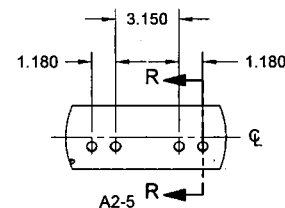
DETAIL J
SCALE 2X



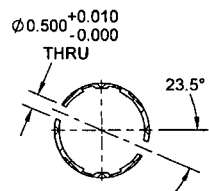
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SCALE 2X



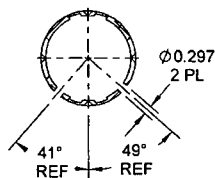
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SCALE 2X



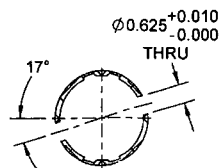
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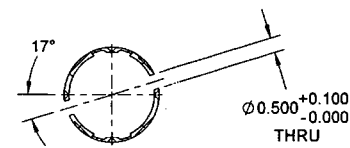
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



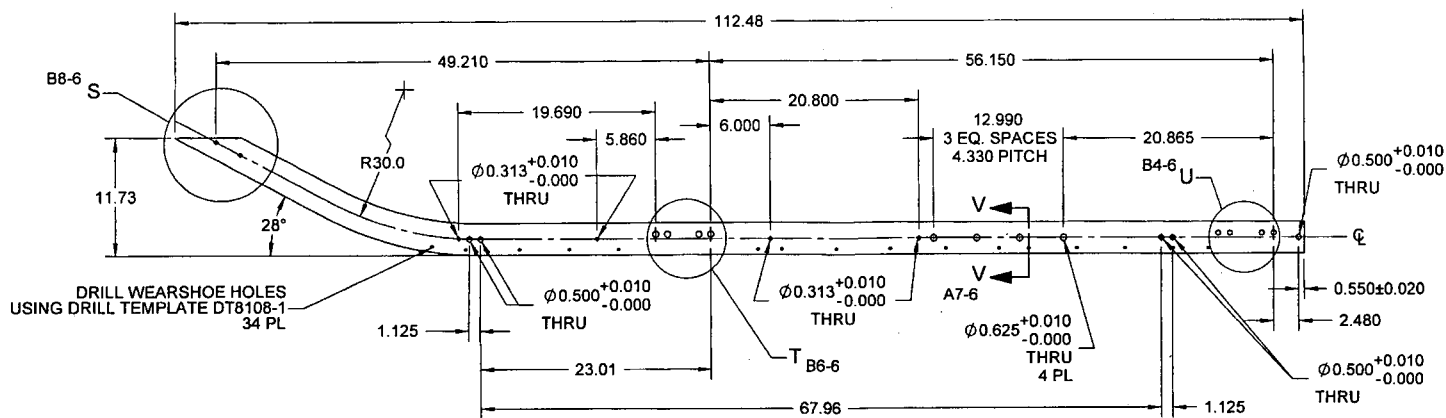
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SCALE 3X, 4 PL

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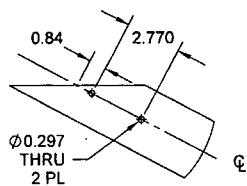
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APPROVED		TITLE 350 SKIDTUBE ASSEMBLY
DE APPR.		SCALE NTS
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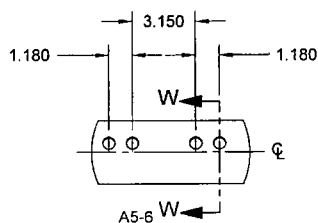
51804



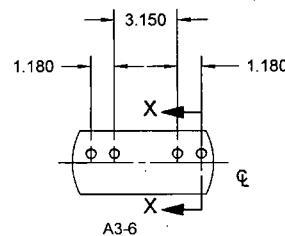
D2750-3 LH SKIDTUBE



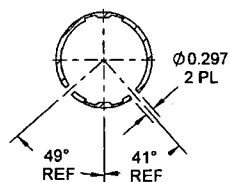
DETAIL S
D8-6
SCALE 2X



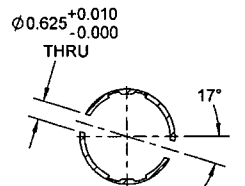
DETAIL T
C5-6
SCALE 2X



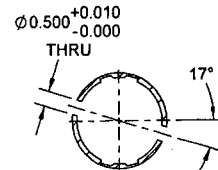
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



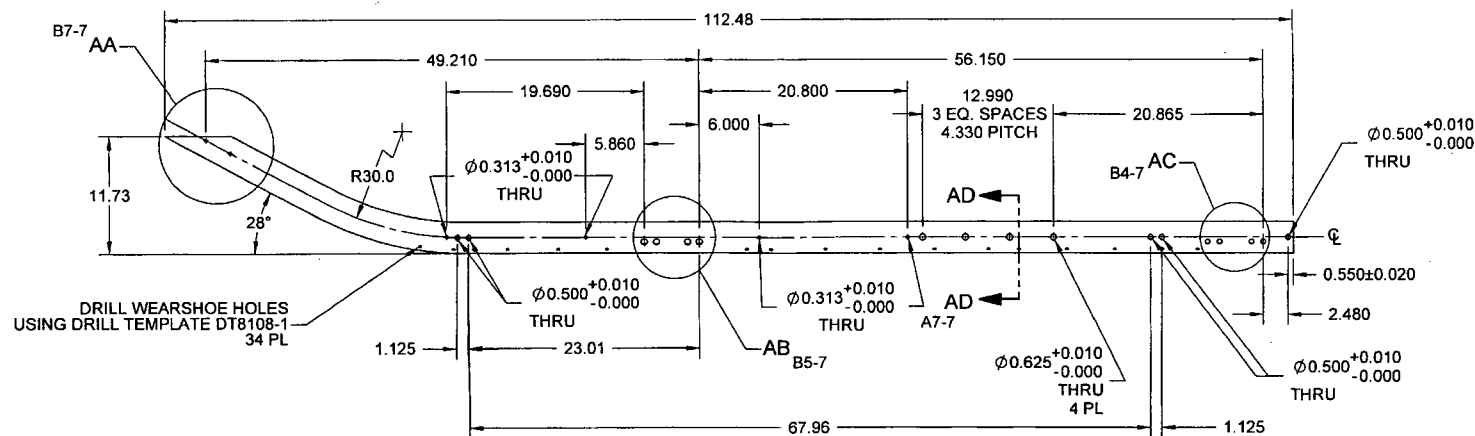
SECTION X-X
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SCALE 3X, 4 PL

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08-07-16

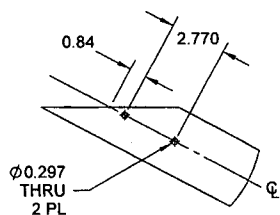
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MFG. APPR.		TITLE 350 SKIDTUBE ASSEMBLY	SHEET 6 OF 11
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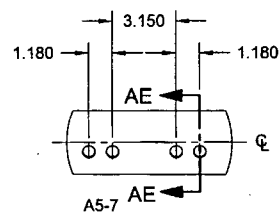
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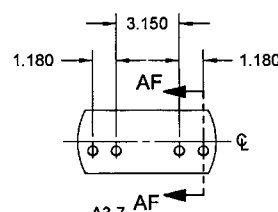
D2750-4 RH SKIDTUBE



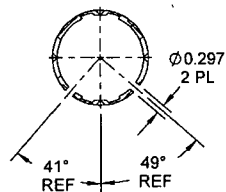
DETAIL AA
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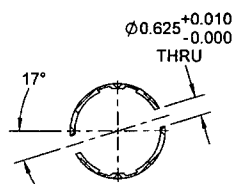
DETAIL AB
SCALE 2X



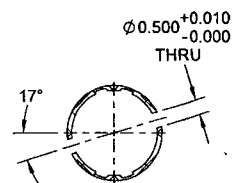
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

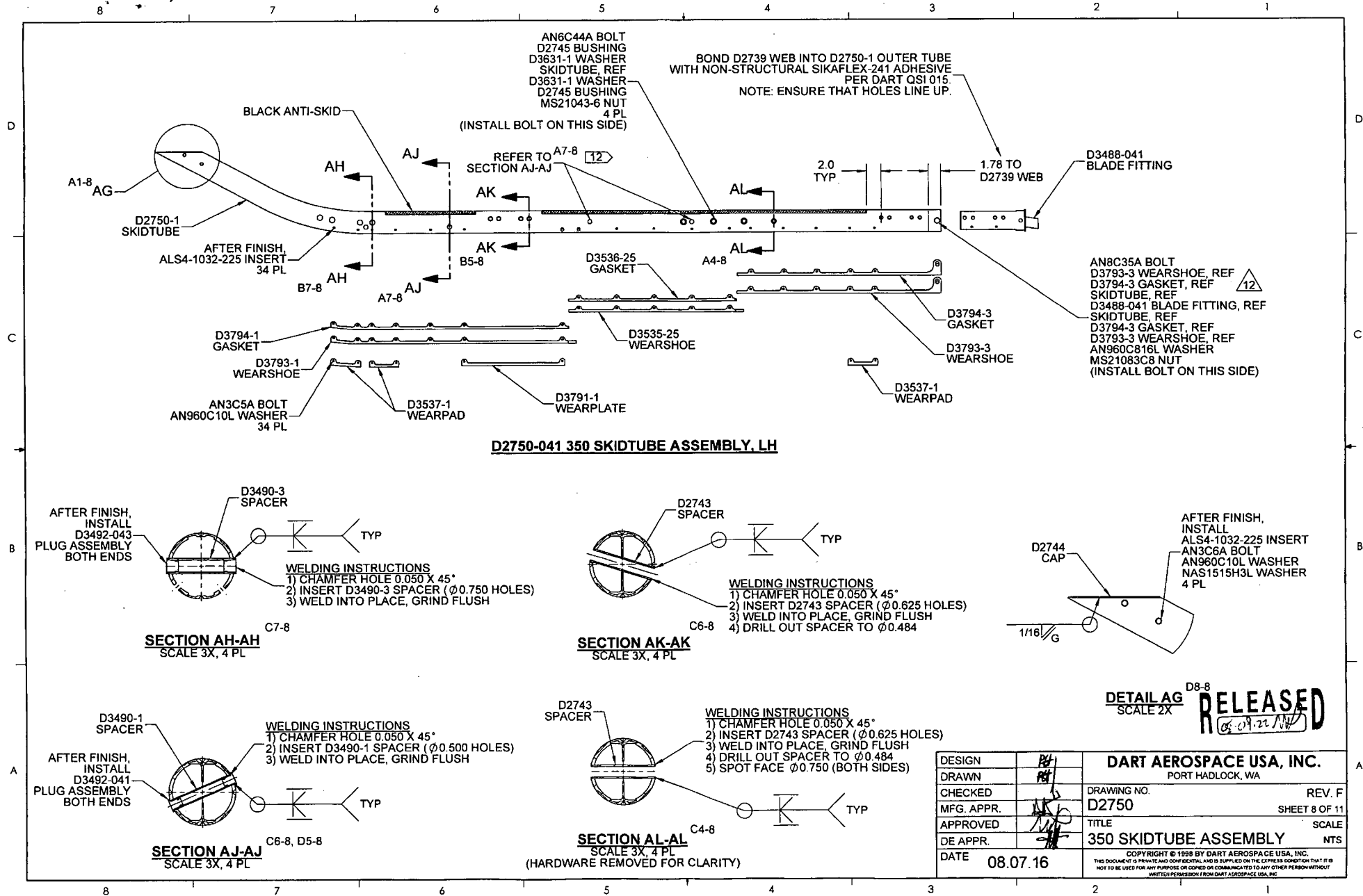


SECTION AF-AF
SCALE 3X, 4 PL

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08-04-2016

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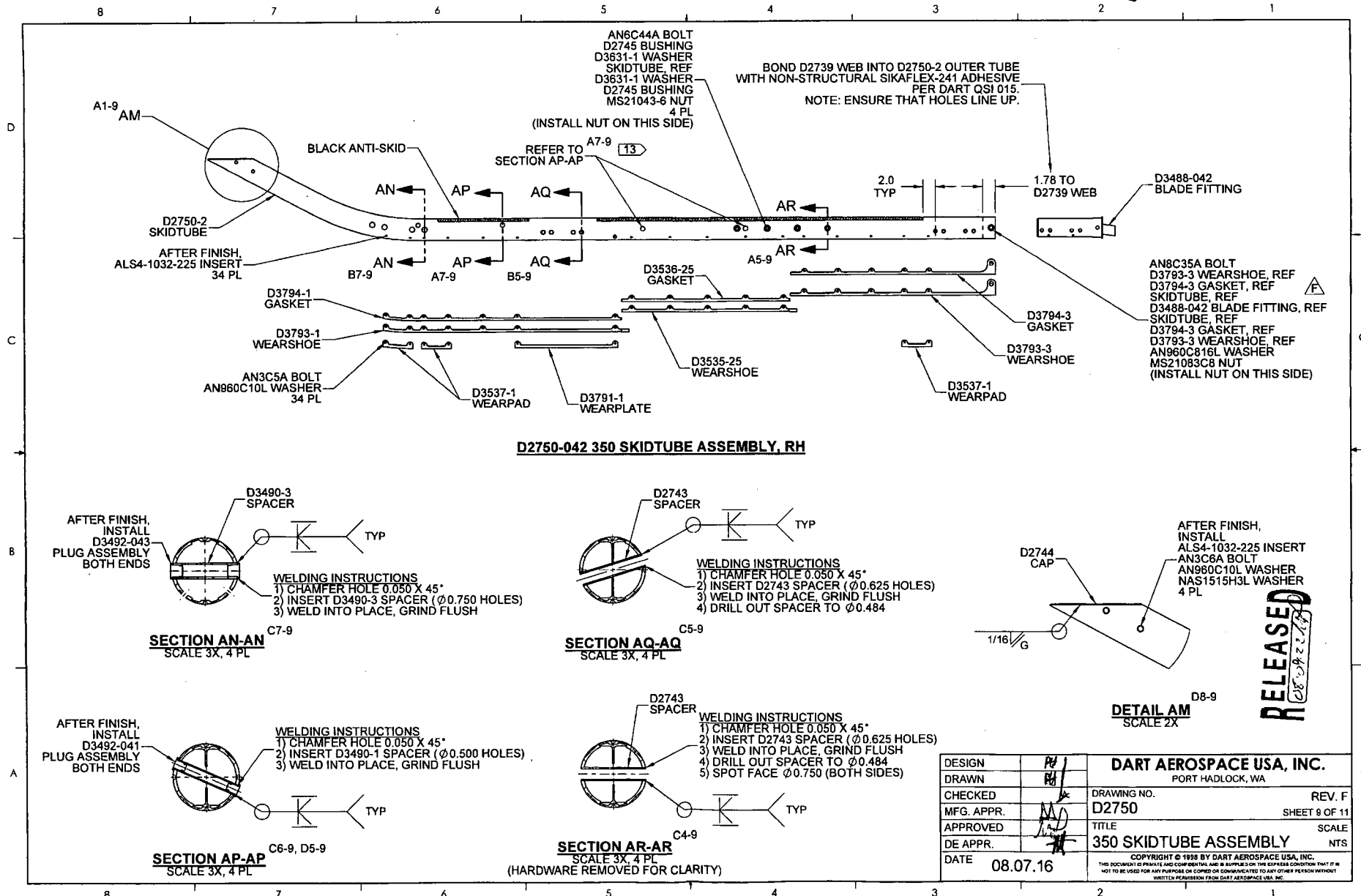
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DETAIL AG SCALE 2X
D8-8
RELEASED
6-09-22

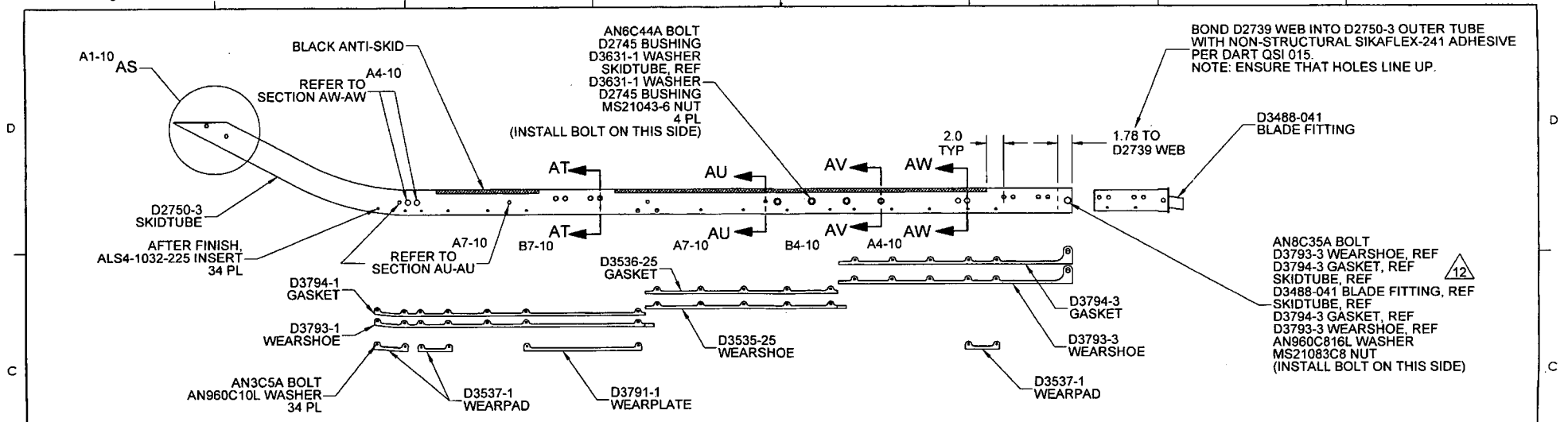
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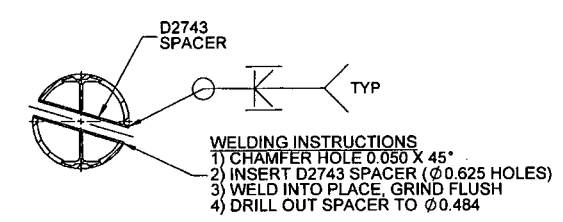


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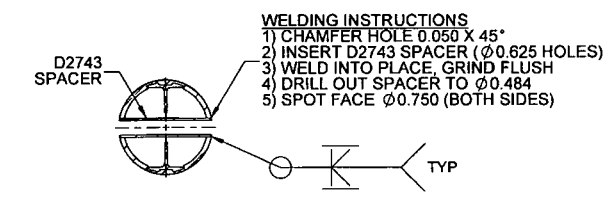
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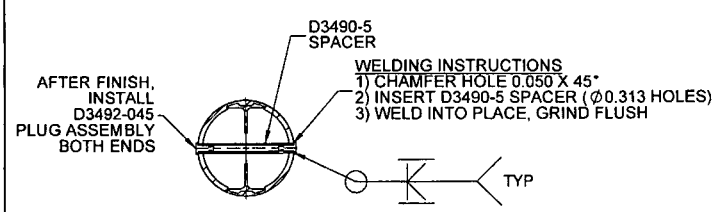
D2750-043 350 SKIDTUBE ASSEMBLY, LH



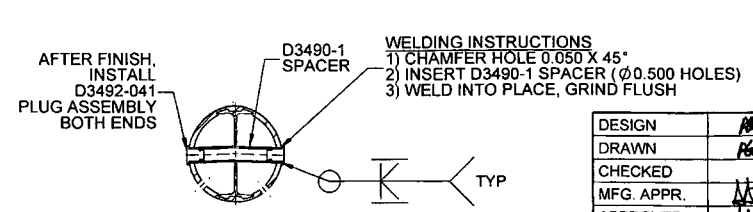
SECTION AT-AT
SCALE 3X, 4 PL



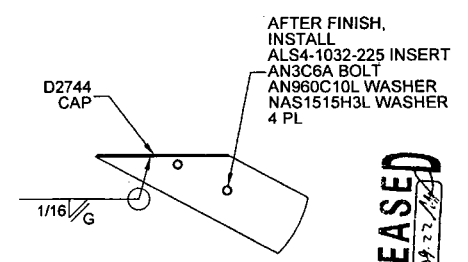
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



DETAIL AS
SCALE 2X

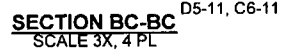
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28 JUN 77

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MFG. APPR.		D2750	SHEET 10 OF 11
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8 7 6 5 4 3 2 1



D2750-044 350 SKIDTUBE ASSEMBLY, RH



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NO. 209

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: A. R. Paul
Job number: 51803
Part number: A350-636-011
Description: 350 SK tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier A. R. Paul Date of Test Coupon 09/09/28
Welder A. R. Paul Date of Test Coupon 09.09.28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld